



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4634-1
Job Sheet 185094



Part No: D4634-1

Job Qty: 1 ea

Part Name: Fwd, Center Ceiling Panel



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/22/18

Job Tracking No:

Due Date: 11/23/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV G SHEETS 10,11,16,17 IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Document release
DL VERIFIED BY:JLM IPP Rev C 13/07/09 Dwg Update DL verf: DD IPP Rev D Dwg Update 13/12/23 DL IPP
REV E Dwg update 14/01/09 DL IPP Rev F Dwg. update 14/02/03 DL IPP Rev G Dwg. Update 15/01/27 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Purchasing	4 pcs	11/23/18	11/23/18	0.00	0.00	Purchasing		NOV 23 2018
140	Packaging	4 pcs	11/23/18	11/23/18	0.00	0.00	Packaging2		NOV 23 2018
150	QC	4 pcs	11/23/18	11/23/18	0.00	0.00	QC6		61
170	Packaging	4 pcs	11/23/18	11/23/18	0.00	0.00	Packaging3		NOV 27 2018
180	QC21-SA	4 Ea	11/23/18	11/23/18	0.00	0.00	QC21		NOV 27 2018

Part Op 140 - Receive & Inspect for Damage & Mat'l Certs

Descriptions: 150 - QC6- All purchased or subcontracted products

170 - Identify as per dwg & Stock Location:

180 - QC21- Final Inspection - Work Order Release

PO 041442 oct 24. 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4634-1P	Fwd, Center Ceiling Panel	4 pcs (1 ea)	110-Purchasing	5131077
MLEXS.093-F6006-07	GE Plastics Lexan Sheet (Light Grey)	69.2000 sf (17.3 ea)	110-Purchasing	5131078

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Purchasing	D4634-1P	4	1	0
	MLEXS.093-F6006-07	69	1,735	0

Part Specifications



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

ould not be found.

Plex 10/22/18 2:54 PM Dart.lajeunesse.marie

Container No: S131079



Part: D4634-1

Job No: 185094

Serial No/Batch: S131079

Revision: G

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/23/18

DQA: _____ Date: _____

QA Closed: _____ Date: _____

DAS
53
1-89

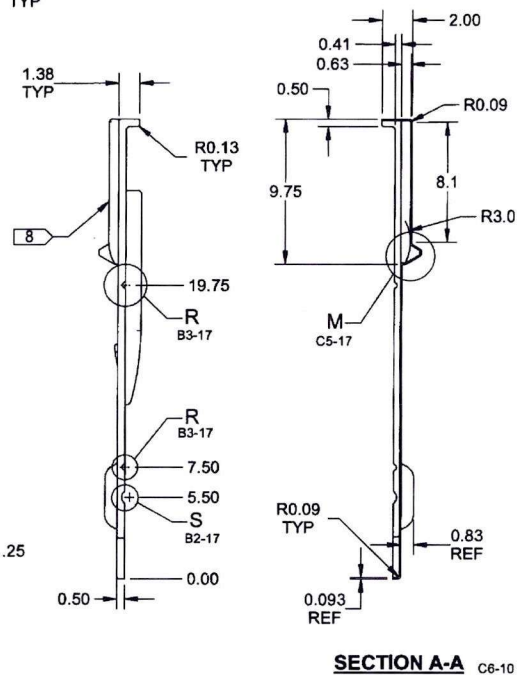
DEC 13 2018

WORK ORDER NON-CONFORMANCE / UPDATE


DART
AEROSPACE
Work Order update only ☐

Work Order: <u>185094</u> Part No. <u>D4634-1</u> NCR No. <u>18-7035</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☒</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☒	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☒																			
Date : <u>18/11/27</u>	Step #: <u>110</u>	QTY Effective : <u>5</u>		MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition		PD 18-11-27																	
Did not cut two holes on side at 7.50" and 19.75"		Need to be cut at small tabs while assembling inspect holes will be rework in house		Completed By																	
				AT 18/11/27																	
				Lead hand / Supervisor Approval Verification																	
				PD 18-11-27																	
QC / QA Coordinator Approval		PD 18-11-27																			

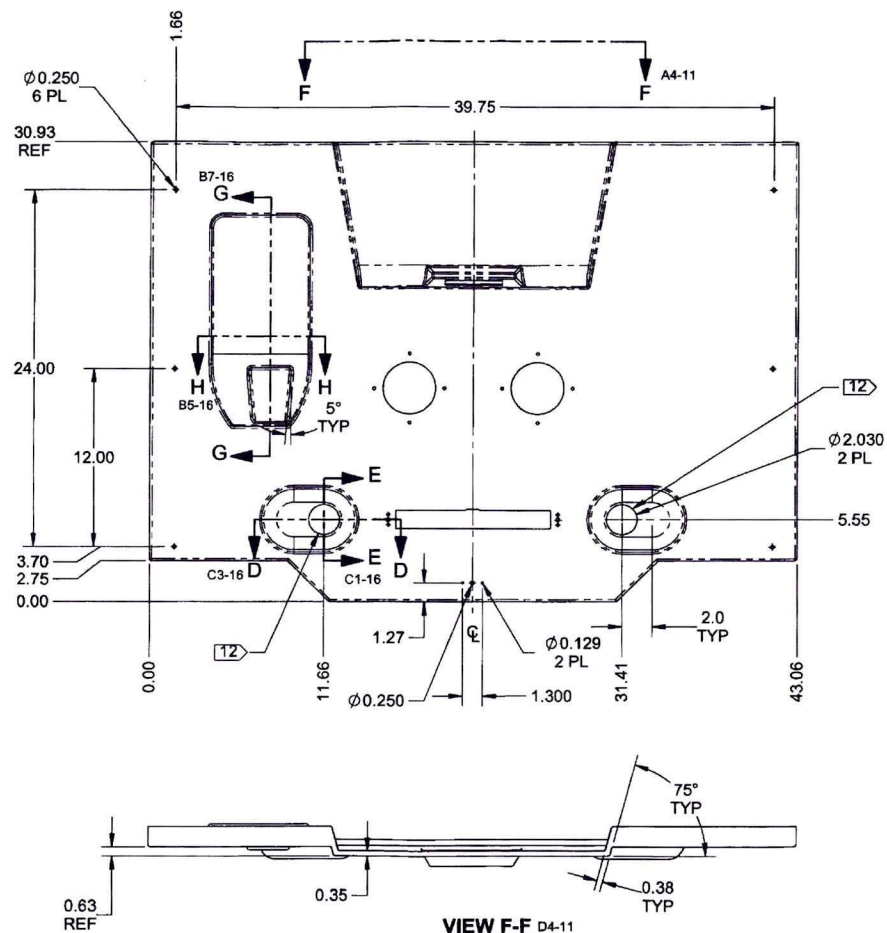
Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☒ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : <u>Supplier</u>					
Misidentified ☐	☐ Past Due						



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 185094 MLS
18-10-22

2015 JAN 26 *gr*

APPROVED	DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4634 TITLE CENTER CEILING PANELS COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	REV. C SHEET 10 OF 10 SCALE NTS
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	CHECKED	AK		
	MFG. APPR.	DL		
	APPROVED	HS		
	DE APPR.	DS		
DATE		14.11.28		



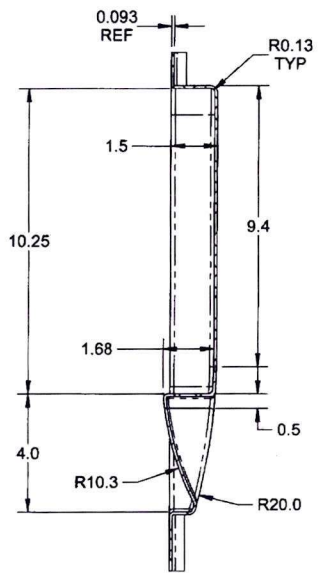
D4634-1 FWD, CENTER CEILING PANEL
AUXILIARY VIEW

APPROVED

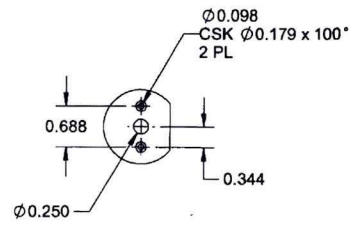
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AK	DRAWING NO.	REV. G
MFG. APPR.	DL	D4634	SHEET 11 OF 17
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DE APPR.	DS	CENTER CEILING PANELS	NTS
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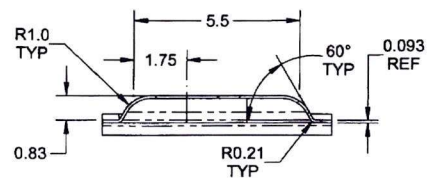
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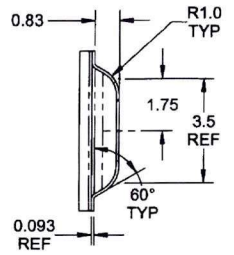
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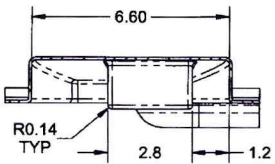
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B4-12
B4-14



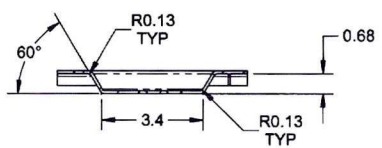
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C4-15



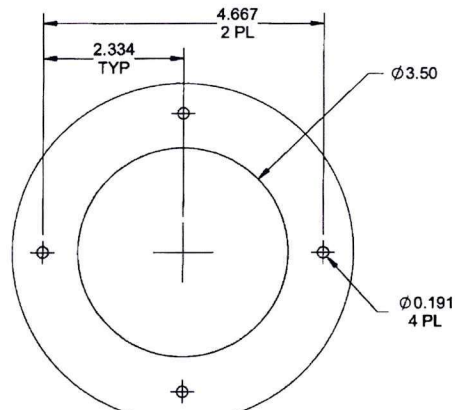
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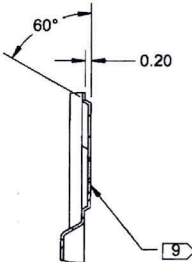
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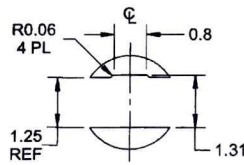
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DETAIL B
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DETAIL I
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B2-14
C2-14



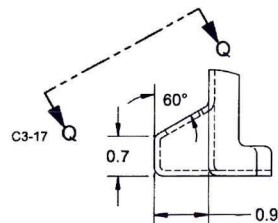
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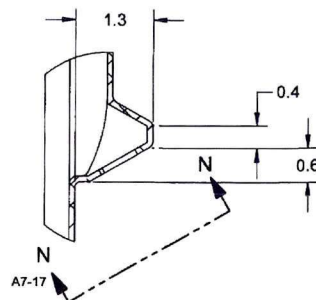
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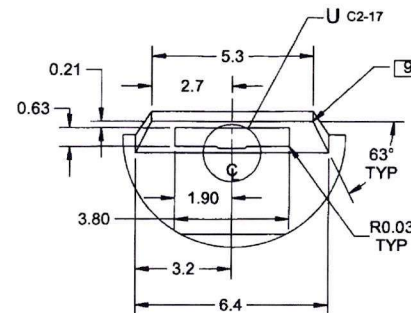
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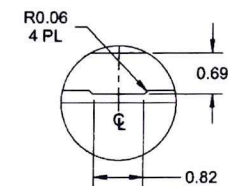
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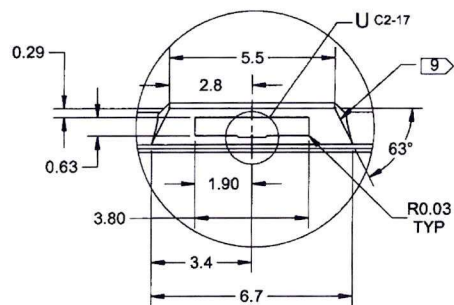
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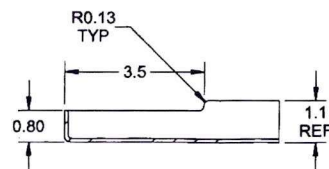
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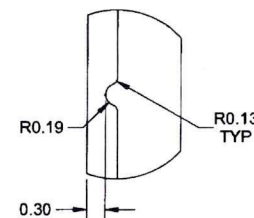
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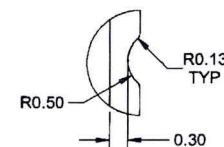
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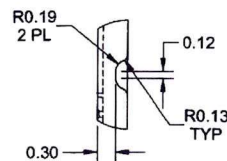
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DETAIL R B3-10
SCALE 4X C3-10
B2-12



DETAIL S B3-10
SCALE 4X C2-12



DETAIL T C2-14
SCALE 4X

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2015 JAN 26

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DE APPR.	DS
DATE	14.11.28

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4634	REV. G
TITLE CENTER CEILING PANELS	SCALE NTS
SHEET 17 OF 17	
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041442**

Supplier: PLA002-VC
Plas-Tech
115 Applewood Crescent
Concord
ON
L4K 5C1 Canada
Phone: 416-736-0004
Fax: 416-736-0010

PO No: PO041442

PO Date: 10/24/18

Due Date: 11/21/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lussier, Patrick Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Revision

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185086	D4635-1P			Fwd Ceiling Panel, LH : Various STC's As Per Dwg D4635 Rev. F	Firmed	-	11/21/18	5 pcs	0 pcs	5 pcs	\$225.00/pcs	\$1,125.00
2	185089	D4635-3P			Aft Ceiling Panel, LH : Various STC's As Per Dwg D4635 Rev. F	Firmed	-	11/21/18	5 pcs	0 pcs	5 pcs	\$225.00/pcs	\$1,125.00
3	185093	D4635-2P			Fwd Ceiling Panel, RH : Various STC's As per Dwg D4635 Rev. F	Firmed	-	11/21/18	5 pcs	0 pcs	5 pcs	\$225.00/pcs	\$1,125.00
4	185094	D4634-1P			Fwd, Center Ceiling Panel : Various STC's As Per DWG D4634 REV. G	Firmed	-	11/21/18	5 pcs	0 pcs	5 pcs	\$225.00/pcs	\$1,125.00
5	185099	D4634-3P			Middle, Center Ceiling Panel : Various STC's As Per Dwg D4634 Rev G	Firmed	-	11/21/18	5 pcs	0 pcs	5 pcs	\$225.00/pcs	\$1,125.00
6	185101	D4634-5P			Aft, Center Ceiling Panel : Various STC's As Per Dwg D4634-5 Rev. G	Firmed	-	11/21/18	5 pcs	0 pcs	5 pcs	\$225.00/pcs	\$1,125.00
7	185823	D4635-4P			Aft Ceiling Panel, RH : Various STC's As Per Dwg D4635 Rev. F.	Firmed	-	11/21/18	5 pcs	0 pcs	5 pcs	\$225.00/pcs	\$1,125.00

Grand Total: \$7,875.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO041442

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Plex 11/2/18 2:35 PM dart.Lussier.Patrick



115 Applewood Crescent
Concord, ON, L4K 5C1
PLASTECHONLINE.COM

P- 416 736 0004
F- 416 736 0010

Packing Slip

Shipment Number: 32545
Shipment Date: 11/22/2018
BOL Number:
Customer Key: C1887
Salesperson: MIKE AUBE
Page Number: 1 of 1

B DART AEROSPACE LTD.
I 1270 ABERDEEN STREET
L HAWKESBURY ON K6A 1K7
L CA
T Attn: DALE BATES
O Buyer Contact: PATRICK LUSSIER

S DART AEROSPACE
H 1270 ABERDEEN STREET
I HAWKESBURY ON K6A 1K7
P CA
T Attn: PATRICK LUSSIER
O

Purchase Order
41442

Sales Order
SO-026069

Incoterms
EX WORKS

Payment Method
COL

Carrier Account #
151793240

Ship Via

FEDERAL EXPRESS - Priority Overnight

Tracking Number

Item Number
Revision

Description

DAS
61
9-89

Quantity
Shipped UOM

D4634-1R - Rev.: G

FWD, CENTER CEILING PANEL

5 EA

D4634-3P - Rev.: G

MIDDLE, CENTER CEILING PANEL

5 EA

D4634-5P - Rev.: G

AFT, CENTER CEILING PANEL

5 EA

Number of Containers

Gross Weight

Shipped By

Certificate Of Conformance



Customer: DART AEROSPACE LTD

P.O. # 41442

SO # 026069

Part #	<u>4634-1P</u>	DAS 61 9-89	Qty.	<u>5</u>	Batch #	<u>-004</u>
Description	<u>FWD, CENTER CEILING PANEL</u>		Material usage	<u>3 SHEETS</u>	Lot#	<u>DART0116 0007424014</u>
Part #	<u>4634-3P</u>		Qty.	<u>5</u>	Batch #	<u>-005</u>
Description	<u>MIDDLE, CENTER CEILING PANEL</u>		Material usage	<u>3 SHEETS</u>	Lot#	<u>DART0116 0007424014</u>
Part #	<u>4634-5P</u>		Qty.	<u>5</u>	Batch #	<u>-006</u>
Description	<u>AFT, CENTER CEILING PANEL</u>		Material usage	<u>3 SHEETS</u>	Lot#	<u>DART0116 0007424014</u>
Part #			Qty.		Batch #	
Description			Material usage		Lot#	
Part #			Qty.		Batch #	
Description			Material usage		Lot#	
Part #			Qty.		Batch #	
Description			Material usage		Lot#	
Part #			Qty.		Batch #	
Description			Material usage		Lot#	
Part #			Qty.		Batch #	
Description			Material usage		Lot#	

Note: All parts are not identified as meeting QSI044.

By: AS
(Approved QA Signatory)

Date: Nov. 22, 2018

C OF C # 091

Page: 1 of 1

Plas-Tech Inc. 115 Applewood Cres. Concord, Ontario L4K 5C1 Tel: (416) 736-0004 Fax: (416) 736-0010

Email: info@plasteconline.com, Web: www.plasteconline.com